

Work Order ID 53900

November 23, 2009 1:22:22 PM



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Item ID:	D2739	Accept		Setup	Start	
Revision ID:	D				Stop	
Item Name:	350 I Beam					
Start Date:	23/11/2009	Start Qty: 11.00		Cust Item ID:		
Required Date:	27/11/2009	Req'd Qty: 11.00		Customer:		
Reference:						

Approvals:	Process Plan:	<u>RI</u>	Date:	<u>09/11/23</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2739	Rev D

100		0.00							
	Skidtubes								<u>11</u> <u>09/11/24</u>

Skidtubes	Memo	0.00
Skidtubes	1-Cut D2600-5 to length as per Dwg D2739. 2-Drill pilot holes in web using drilling Jig DT8162 as per Dwg D2739 3-Use uni-bit to open holes to finish size as per Dwg D2739. 4-Bevel Fwd end of extrusion and Deburr holes and ends. 5-Dburr	

110	QC5- Inspect part completeness to step on W/O	0.00	

QC	Memo	0.00	
Quality Control			

120	Chemical Conversion Coat per QSI005 4.1	0.00	

HandFinish	Memo	0.00	
Hand Finishing			

DP 9-11-25 (11)

11BE 09/11/25 (11)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D2739

Accept



Setup Start



Revision ID: D

Stop



Item Name: 350 I Beam

Start Date: 23/11/2009 Start Qty: 11.00



Cust Item ID:

Required Date: 27/11/2009 Req'd Qty: 11.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

11 11/11/25

140

Identify as per dwg & Stock Location: 2.6

0.00



Packaging

Memo

0.00

Packaging

11 11/11/25

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/26

mf 09-11-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 53900



Parent Item: D2739RevD



Parent Item Name: 350 I Beam

Start Date: 23/11/2009

Required Date: 27/11/2009

Comments:

Start Qty: 11.00

Required Qty: 11.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2600-5-108RevD1		Manufactured	No			100	Each	258.0000	11.0000			
Extrusion 'I Beam' thin												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	258	
29985	1	
38589	9	
47814	248	

11 11/11/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

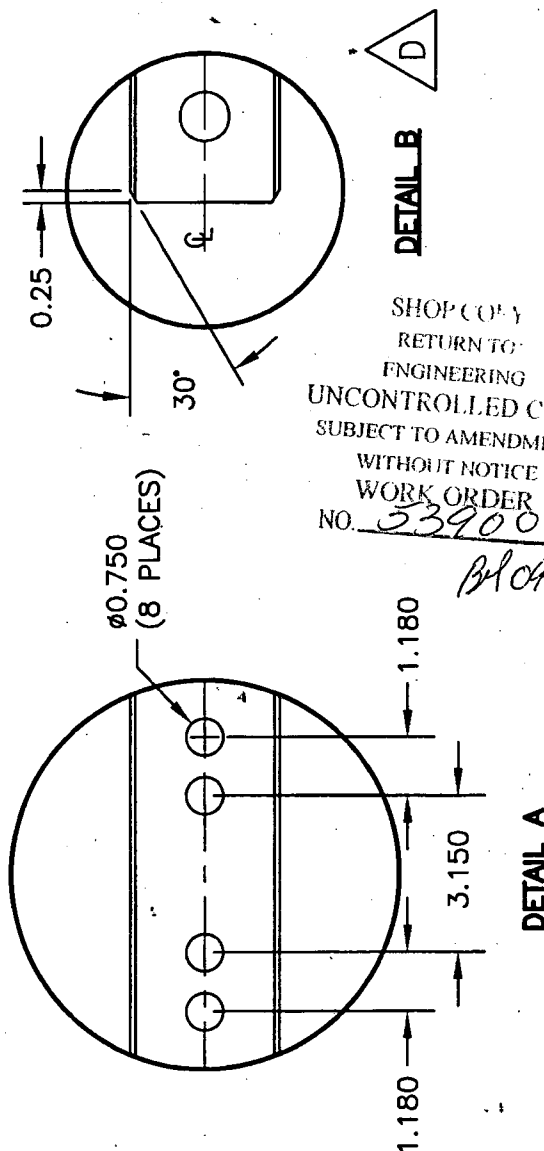
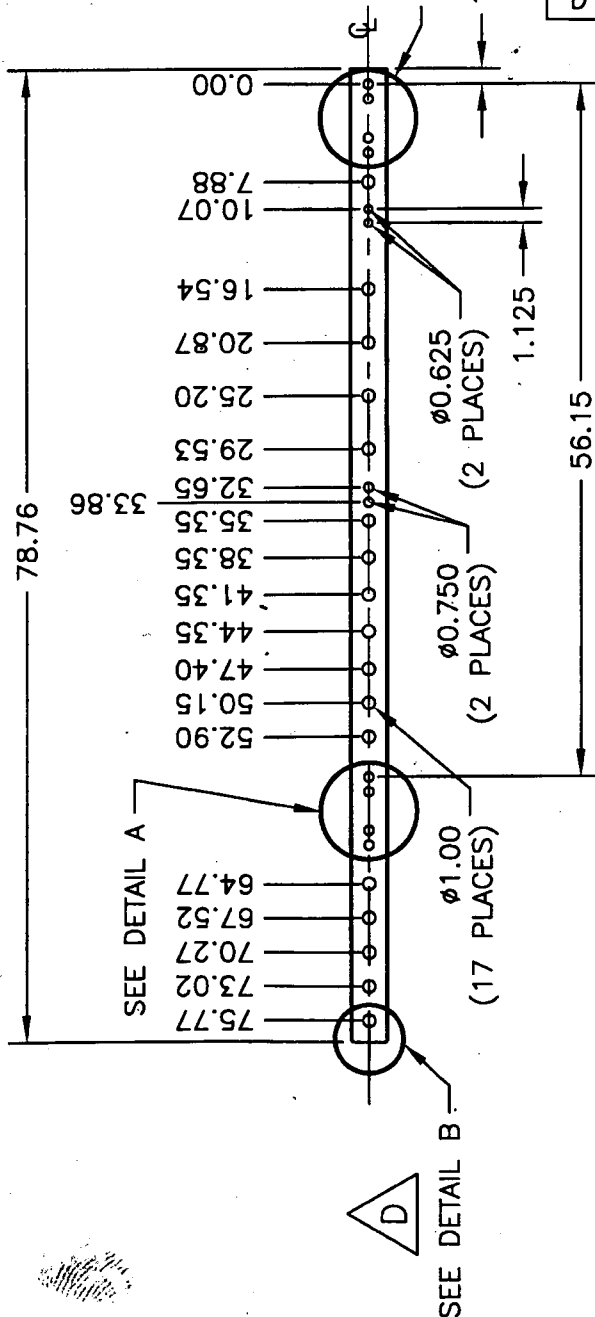
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



A	98.04.16	NEW ISSUE
B	98.11.18	CHANGE HOLES FOR COMPATABILITY WITH AIRCRUISER FLOATS
C	06.01.05	ADD/MOVE HOLES FOR COMPATABILITY W/APICAL FLOATS
D	07.05.29	ADD BEVEL TO FWD END; ADD DETAIL B



25

NOTES:

- 1) MATERIAL: MAKE FROM D2600-5 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) PART IS SYMMETRIC ABOUT C

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